

Tuesday, December 22, 2015 4:04:21 PM

Item ID: D135-751-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: EC135 Replacement Wearplates for Standard Skidtubes Fit LH or RH

Start Date: 12/22/2015 **Start Qty:** 2.00

?

Cust Item ID:

Required Date: 1/7/2016 **Req'd Qty:** 2.00

?

Customer:

Reference:

Approvals: Process Plan: [Signature] Date: 5-12-22 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D135-751	Rev C

100 Document Control
 +100+ DOCUMENT CONTROL

100

DC

Doc.Control -USB or Paperwork

Memo

Photocopy bluefile & type labels per PPP D135-751-043 CHG002

110	Pick Kit	0.00
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1 10

Packaging

Packaging

Memo

120	QC4- 100% Inspect kits for completeness	0.00
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120

QC

Quality Control

Memo

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 140360***140360***

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Tuesday, December 22, 2015 4:04:21 PM

Item ID: D135-751-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: EC135 Replacement Wearplates for Standard Skid tubes Fit LH or RH
Start Date: 12/22/2015 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 1/7/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D135-751-043								
	Location: <u>Off Shore</u>								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

SA 120160123

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Picklist Print

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Page 1

Work Order ID: 140360

140360

Parent Item: D135-751-043

D135-751-043

Parent Item Name: EC135 Replacement Wearplates for Standard Skidtubes Fit LH or RH

Start Date: 12/22/2015

Required Date: 1/7/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-12-18 JLM
13.12.11 ECN13-619/ CHG002 DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C4A *AN3C4A* Bolt		Purchased	No			110	Each	565.0000	38	76			
-----------------------------------	--	-----------	----	--	--	-----	------	----------	---------------	----	--	--	--

Location	Loc Qty	Loc Code
FG	20	
122814	20	
FP001	533	
M132317	76	
M132551	61	
M132803	50	
M133440	346	
ST349	12	
M133234	12	

D3512-041 *D3512-041* Wearplate		Manufactured	No			110	Each	8.0000	2	4			
--	--	--------------	----	--	--	-----	------	--------	--------------	---	--	--	--

Location	Loc Qty	Loc Code
ST610	8	
138289	8	

D4918-047 *D4918-047* Wearplate Aft		Manufactured	No			110	Each	4.0000	1	2			
--	--	--------------	----	--	--	-----	------	--------	--------------	---	--	--	--

Location	Loc Qty	Loc Code
FP001	4	
130440	4	

BAS
27
9-89

BAS
27
9-89

BAS
27
9-89

~~12/22/15~~ 134055

~~12/22/15~~

JAN 6
9-89

DAS
6
9-89

DAS
28
9-89

DAS
28
9-89

DAS
6
9-89

JAN 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Picklist Print

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Page 2

Work Order ID: 140360

140360

Parent Item: D135-751-043

D135-751-043

Parent Item Name: EC135 Replacement Wearplates for Standard Skidtubes Fit LH or RH

Start Date: 12/22/2015

Required Date: 1/7/2016

Start Qty: 2.00

Required Qty: 2.00

D4918-1

Manufactured No

110

Each

12.0000

1 2

6
9-89

DAS
28
9-89

D4918-1

Wearplate Fwd

**

Location

Loc Qty

Loc Code

FP001

10

130441

1

132158

9

FP002

2

119891

2

110

Each

7.0000

1 2

DAS
6
9-89

DAS
28
9-89

**

DAS
27
9-89

D4918-3

Manufactured No

D4918-3

Wearplate Center Fwd

Location

Loc Qty

Loc Code

FP002

7

130442

7

110

Each

5.0000

1 2

DAS
6
9-89

DAS
28
9-89

**

DAS
27
9-89

D4918-5

Manufactured No

D4918-5

Wearplate Center Aft

Location

Loc Qty

Loc Code

FP002

5

130443

5

2

DAS
27
9-89

JAN 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		☐ OTHER : _____							

Picklist Print

Tuesday, December 22, 2015 4:04:26 PM

Work Order ID: 140360

140360

Parent Item: D135-751-043

D135-751-043

Parent Item Name: EC135 Replacement Wearplates for Standard Skid tubes Fit LH or RH

Start Date: 12/22/2015

Required Date: 1/7/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0332R

Purchased

No

110

Each

2,966.000

38 76

NAS1149C0332R

WASHER

**

6631A x 42

DAS

1322 132262 x 40

9-89

DAS
27
9-89 X2

Location

Loc Qty

Loc Code

FP001

1547

m132262

4

m132930

1004

m133284

539

GA

343

m133284

343

ST266

1076

m133284

1076

DAS

28

9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	☐ OTHER : _____			

PARTS LIST:

THE PARTS LISTS IN SECTION 32.9 OF ICA-D135-751 (PAGE 35) AND SECTION 5.0 OF IIN-D135-751 (PAGE 11) ARE AMENDED AS FOLLOWS FOR D135-751-011 @ CHG 002 AND LATER.

32.9 PARTS LIST (ICA-D135-751)**5.0 PARTS LIST (IIN-D135-751)**

Item	QTY -011	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	X			D135-751-011	SKIDTUBE INSTALLATION
	1	X		D135-751-041	REPLACEMENT SKIDTUBE
			X	D135-751-043	WEARPLATE KIT

IS:

20A	1		1	D4918-1	WEARPLATE (REPLACES D3508-1)
21A	1		1	D4918-3	WEARPLATE (REPLACES D3508-3)
22A	1		1	D4918-5	WEARPLATE (REPLACES D3508-5)
23A	1		1	D4918-047	WEARPLATE (REPLACES D3508-7)
27	2		2	D3512-041	WEARPLATE (REPLACES D3512-1)

WAS:

20A	1		1	D3508-1	WEARPLATE
20B	1		1	D3558-1	GASKET
21A	1		1	D3508-3	WEARPLATE
21B	1		1	D3558-3	GASKET
22A	1		1	D3508-5	WEARPLATE
22B	1		1	D3558-5	GASKET
23A	1		1	D3508-7	WEARPLATE
23B	1		1	D3558-7	GASKET
27	2		2	D3512-1	WEARPLATE

THE PARTS LIST FOR THE DSI 9661-011 KIT IS AS FOLLOWS:

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9661-011	WEARPLATE UPGRADE KIT
1	D4918-047	WEARPLATE
2	D3512-041	WEARPLATE

DESIGN	DW	DART AEROSPACE USA, INC KENT, WA	
DRAWN	DW		
CHECKED	<i>RP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>N/A</i>	DSI 9661	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	REVISED WEARPLATE KIT	NTS
DATE	13.08.21	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

REFERENCE ONLY

5.0 PARTS LIST

Item	Qty -011	Qty -041	Qty -043	Qty -101	Part Number	Description
	X				D135-751-011	SKIDTUBE INSTALLATION
	1	X			D135-751-041	REPLACEMENT SKIDTUBE
			X		D135-751-043	WEARPLATE KIT
				X	D135-751-101	SKIDTUBE EXTENSION KIT
1		1			D3507-041	SKIDTUBE ASSEMBLY
2	4				**BRS8-96/48SZ-M8-W2	CLAMP
3	8				**LN9038-08032	SCREW
4		1			*D2965	CAP
5		1			*D2965-3	CAP
6		2			***AELS-1032-130	INSERT
7		2			***AELS-1032-225	INSERT
8		2			*AN3C5A	BOLT
9		2			*AN960C10L	WASHER
10		2			*AN526C1032-10	SCREW
20A		1	1		*D3508-1	WEARPLATE
20B		1	1		*D3558-1	GASKET
21A		1	1		*D3508-3	WEARPLATE
21B		1	1		*D3558-3	GASKET
22A		1	1		*D3508-5	WEARPLATE
22B		1	1		*D3558-5	GASKET
23A		1	1		*D3508-7	WEARPLATE
23B		1	1		*D3558-7	GASKET
24		38			*AELS-1032-130	INSERT
25	8	30	38		*AN3C4A	BOLT
26	8	30	38		*AN960C10L	WASHER
27	2		2		D3512-1	WEARPLATE
30		1			*AELS-1032-225	INSERT
31		1			*AN3C4A	BOLT
32		1			*AN960C10L	WASHER
40		4			*D3492-041	PLUG ASSEMBLY
41		4			***NAS1611-010	O-RING
42		2			*D3492-047	PLUG ASSEMBLY
43		2			***NAS1611-007	O-RING
44		4			*D3506-1	DOUBLER
45		8			*MS20601AD4W3	RIVET
46		2			*D3506-3	DOUBLER
47		4			*MS20601AD4W3	RIVET
48		4			*D3492-043	PLUG ASSEMBLY
49		4			***NAS1611-013	O-RING
50				1	D3510-041	INSERT ASSEMBLY
51				2	***AELS-1032-130	INSERT
52				6	***AELS-1032-225	INSERT
53				2	***ALS4-428-165	INSERT
54				2	AN4C7A	BOLT
55				2	AN960C416L	WASHER
56				2	AN3C4A	BOLT
57				8	AN3C7A	BOLT
58				10	AN960C10L	WASHER

* PART IS INCLUDED WITH D3507-041 SKIDTUBE ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER, LISTED AS REFERENCE ONLY

*** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE